ABSTRACT

A tool holder attachment structure that can firmly secure a main shaft (1) to a main shaft (2) is provided. A plurality of elastic engagement pieces (6) are disposed at the inner surface section of an attachment hole (3) of the main shaft (1) at a plurality of positions along the axial center. The plurality of elastic engagement pieces (6) can abut a tapered outer perimeter surface (12a) of the tool holder (3) and be elastically deformed slightly in the radial direction. When the plurality of elastic engagement pieces (6) are elastically deformed radially and tightly abutted against the tapered outer perimeter surface (12a) of the tool holder (3), the plurality of elastic engagement pieces (6) links roughly the entirety of the shank (12) to the inner surface of the attachment hole (3) with a uniform force. Furthermore, in this state, an elastic flange (14) is elastically deformed and reliably abuts the end surface of the main shaft (1).